

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018691**Date Inspected:** 26-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of joint BK004A2-026-002 located on PCMK BK004-026, bent side plate to bottom plate.

Welder was identified as 040302. QC was identified as ZPMC CWI Xu Le Feng (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Yu Zhi Lai (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2132 as verbally identified by QCA1.

Heat straightening of PCMK OBG Lift 13, SP3083A, weld #1. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat treatment operation and recording data was QCA1, who was not a CWI. Heat treatment observed by this QA Inspector and recorded by QCA1 appeared to comply with HSR1(B)-9858 as presented to this QA Inspector by QCA1.

Heat straightening of PCMK OBG Lift 13, SP3081B, welds #120~139, 156~163. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat treatment operation and recording data was QCA1, who was not a CWI. Heat treatment observed by this QA Inspector and recorded by QCA1 appeared to comply with HSR1(B)-9858 as presented to this QA Inspector by QCA1.

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Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

ZPMC workers performing match drilling at the connection plates between north/east towers and south/west towers, lift 5, skin A. All four sections are attached at skins A and E. The four sections form one assembly.

No apparent welding being performed in Bay 11.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of weld joint TR1E-PP104-010 located outside PCMK OBG 11DW, traveler rail bracket. Welder was identified as 053486. QC was identified as ZPMC CWI Li Yang (QC2). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Shen Jian Bo (QCA2), who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-2231-TC-U4c-F and WPS-B-T-2233-TC-U4c-F as displayed on ZPMC Weld Repair Report B-CWR2127 presented to this QA Inspector and verbally identified by QCA2. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cao Hai Zhou.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. All four towers, lift 5 had been removed and no longer positioned on top of the respective lift 4. No work was being performed on the Heavy Dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
